

13/05/2009 9:28:30 AM

Process Sheet

CU-DAR001 Dart Helicopters Services Drawing Name : HELI-ACCESS STEP LH (FOLDING)
 : 47930
 : 12567
 :
 : 13/05/2009 S.O. No. :
 : NC
 : 11 Type : LARGE FAB ASSY
 : 46599
 Part Number : D412630033
 Drawing Number : IIN D412-630
 Project Number : N/A
 Drawing Revision : M
 Material :
 Due Date : 20/05/2009 Qty: 4 Um: Each
 Written By :
 Checked & Approved By : MF 09-05-13
 Comment : Est. Rev:A New Issue 06-11-08 JLM
 est rev B ecn 1019, added d2807-041 EC verified by:DD
 Est Rev:C 09-03-02 as per rev.m DD verified by:ec

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



HJ Ca JLD 09/05/20



Comment: DOCUMENT CONTROL

Photocopy bluefile & create labels per PPP D412-630-033 CHG003

Sors/25

2.0 D2012107 Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Clevis

Pick:

Qty	Part Number	Description	Batch
1	D2012-107	Clevis	B46634

Batch

B46634

Ep 09/05/19

3.0 D2803041 Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bracket Assembly

Pick:

Qty	Part Number	Description	Batch
1	D2803-041	Bracket Assembly LH	B46639

Batch

B46639

Ep 09/05/19

4.0 D2804041 Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bracket Assembly

Pick:

Qty	Part Number	Description	Batch
1	D2804-041	Bracket Assembly LH	B46843

Batch

B46843

Ep 09/05/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP LH (FOLDING)

Job Number: 47930

Part Number: D412630033

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2807041

Door prop



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Support Prop

Batch: *B44858*

Ep09/05/19

6.0

D2813

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

Pick:

Qty Part Number

Description

Batch

2 D2813

Washer

B46332

Ep09/05/19

7.0

D3562041

Step Assembly, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Step Weldment LH

Pick:

Qty Part Number

Description

Batch

1 D3562-041

Step Weldment LH

B47207

Ep09/05/19

8.0

D33951

Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Bushing

Pick:

Qty Part Number

Description

Batch

4 D3395-1

Bushing

B46616

Ep09/05/19

9.0

AN3C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

BOLT

Pick:

Qty Part Number

Description

Batch

2 AN3C21A

Bolt

M109148

Ep09/05/19

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Drawing Name: HELI-ACCESS STEP LH (FOLDING)

Job Number: 47930

Part Number: D412630033

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

AN8C16

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description
2	AN8C16	Bolt

Batch

M105969

Ep09/05/19

11.0

AN310C8

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description
2	AN310C8	Nut

Batch

M111279

Ep09/05/19

12.0

MS24665302

Cotter Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Cotter Pin

Pick:

Qty	Part Number	Description
2	MS24665-302	Cotter Pin (or AN380C3-4)

Batch

M106763 (1x)

M111359 (7x)

Ep09/05/19

13.0

NAS1515H3

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total: 24.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
6	NAS1515H3	Washer

Batch

M109268

Ep09/05/19

14.0

NAS1515H5L

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

WASHER

Pick:

Qty	Part Number	Description
4	NAS1515H5L	Washer

Batch

M108964

Ep09/05/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP LH (FOLDING)

Job Number: 47930

Part Number: D412630033

Job Number:



Seq. #:	Machine Or Operation:	Description :
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15.0	NAS1515H8	Washer
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)
Washer

Pick:

Qty	Part Number	Description
4	NAS1515H8	Washer

Batch

M111275

Ep09/05/19

16.0	MS210433	Nut
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)
Nut

Pick:

Qty	Part Number	Description
4	MS21043-3	Nut

Batch

M111383

Ep09/05/19

17.0	MS24693C280	Screw
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)
Screw

Pick:

Qty	Part Number	Description
2	MS24693-C280	Screw (or MS24694-C565)

Batch

M111279

Ep09/05/19

18.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per dwg D412-630 p.14

Coat all hardware with LPS3 rust inhibitor
A/R LPS3 batch: 1109929

COAT exposed HARDWARE WITH LPS PROCYON .

A/R LPS PROCYON BATCH: _____

Ep09/05/19 (4)

19.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

S09/05/19 (x4 LHL)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 47930

Part Number: D412630033

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

21.0

D28061

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bushing

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D2806-1

Bushing

B416609+3
B42174x5

SS 09/05/20

22.0

D28063

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bushing

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D2806-3

Bushing

B416737x5
B42175x3

SS 09/05/20

23.0

D28105

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Strut

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D2810-5

Strut

B41678 1x
B416641 x3

SS 09/05/20

24.0

D33961

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Spacer

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D3396-1

Spacer

B41670x7 B416748x1

SS 09/05/20

25.0

AN4C6A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

M111295

SS 09/05/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP LH (FOLDING)

Job Number: 47930

Part Number: D412630033

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1	AN4C6A	Bolt
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26.0	AN4C10A	Bolt
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
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1	AN4C10A	Bolt	
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M100302

SS 09/05/20 (x4)

27.0	AN4C15A	Bolt
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
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2	AN4C15A	Bolt	
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M111279 x3
M110155 x5

SS 09/05/20 (x4)

28.0	AN44C7A	Eyebolt
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Eyebolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
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1	AN44-C7A	Eyebolt	
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M111279

SS 09/05/20 (x4)

29.0	AN5C15A	Bolt
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
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2	AN5C15A	Bolt	
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M109148

SS 09/05/20 (x4)

30.0	NAS1515H4	Washer
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Comment: Qty.: 7.0000 Each(s)/Unit Total : 28.0000 Each(s)

Washer

Pick: Packing Kit

Qty	Part Number	Description	Batch
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7	NAS1515H4	Washer	
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M111294

SS 09/05/20 (x4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP LH (FOLDING)

Job Number: 47930

Part Number: D412630033

Job Number:



Seq. #:	Machine Or Operation:	Description :
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31.0	NAS1515H5	Washer
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Comment: Qty.: 7.0000 Each(s)/Unit Total : 28.0000 Each(s)

Washer

Pick: Packing Kit

Qty	Part Number	Description	Batch
7	NAS1515H5	Washer	M109430

88 09/05/20 x4

32.0	MS210434	Nut
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Nut

Pick: Packing Kit

Qty	Part Number	Description	Batch
4	MS21043-4	Nut	M111295

88 09/05/20 x4

33.0	MS210435	Nut
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Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Nut

Pick: Packing Kit

Qty	Part Number	Description	Batch
3	MS21043-5	Nut	B10180x9 M11119 x3

88 09/05/20 x4

34.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

88 09/05/25 x440

35.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-033

Location:

PPP Rev:

9/5/25

Scp

36.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

09/05/26

Job Completion



mf 09-05-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

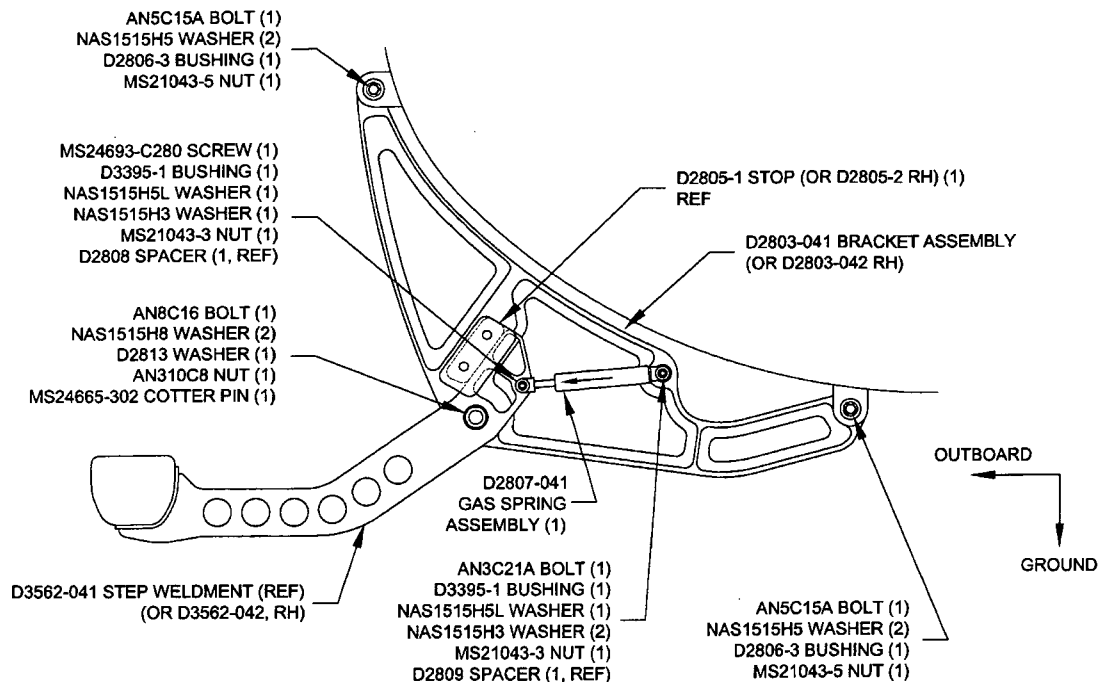
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

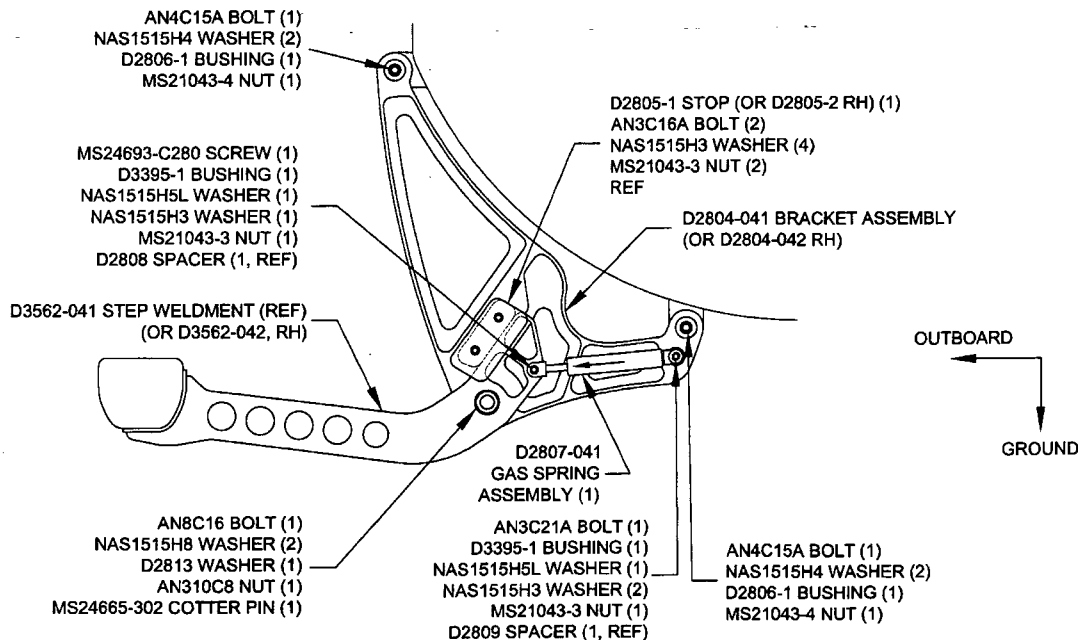
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D412-630-033/-034 Heli-Access-Step™ Installation



**FIGURE 14 – STA 84.29 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)**



**FIGURE 15 – STA 155.06 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)**

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Revision: **M**
Date: 08.12.12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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